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वस्त्रादि — वैमानिकी प्रयोजनो  
के लिये नाईलॉन वेबिंग — विशिष्टि  
( पहला पुनरीक्षण )

**Textiles — Nylon Webbing  
for Aeronautical Purposes —  
Specification**  
( *First Revision* )

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## FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by Textile Materials for Aeronautical and Related Products Sectional Committee had been approved by the Textile Division Council.

This standard was first published in 1968 and has been revised now to align it with latest trade practices.

This standard is based on provisional specification No. IND/ADE/0058 'Webbing nylon for parachute harness — Undyed/olive green and blue' and IND/ADE/0066 'Webbing nylon 44 mm — Undyed/olive green and blue', issued by the Chief Inspectorate of Aerial Delivery Equipment, Agra.

The composition of the Committee responsible for the formulation of this standard is given in Annex H.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

## *Indian Standard*

# TEXTILES — NYLON WEBBING FOR AERONAUTICAL PURPOSES — SPECIFICATION

( *First Revision* )

## 1 SCOPE

**1.1** This standard prescribes the constructional details and other particulars of 2 types of nylon webbing, undyed or dyed, used in personnel parachutes and other aeronautical purposes.

**1.2** This standard does not specify the general appearance, feel, etc, of the webbing (*see also 4.10*).

## 2 REFERENCES

The standards listed in Annex A contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of these standards.

## 3 MANUFACTURE

### 3.1 Yarn

Nylon yarn used in the manufacture of webbing shall be of 840 d. It should be bright and of high tenacity. It should be either of Nylon 6 or Nylon 66. The final ply of the warp and weft yarns should have a minimum of 100 tpm. The single yarns forming the final plied yarn should be twisted together in a single operation.

NOTE - For resin treated tape, manufacturer should issue certificate of compliance of specified twist.

### 3.2 Webbing

#### 3.2.1 Weave

Type 1 nylon webbing shall be woven in double-plain weave. The binder warp ends should weave 2 up, 2 down with one end working as one. The face and back warp yarns shall be woven with 2 ends working as one except the warp yarns forming the

selvedge, which shall be woven with one end working as one. The number of warp yarns used for forming the selvedge shall not exceed 8 for one end and 9 for the other end respectively.

**3.2.1.1** Type 2 shall be woven in 2 up, 2 down herringbone twill with one reversal of twill at the centre. Webbing shall be soft and pliable.

**3.2.2** The finished webbing should be clean, even and well-woven with firm and regular selvages. The webbing should be free from weaving defects and stains. The dyed webbing should be of uniform shade. In case webbings are produced on handloom its end shall be made firm with interlocking thread.

### 3.3 Dyeing

Webbing shall either be yarn-dyed or piece-dyed. The dyeing shall be done preferably with acid/disperse dyes. Metallized/chrome/sulphur dyes shall not be used in production of dyed tapes.

## 4 REQUIREMENTS

### 4.1 Construction

The webbing shall comply with the requirements of Table 1.

**4.2** Length of webbing shall be 100 m per roll when tested in accordance with Annex D. Any other length may also be supplied as agreed to between the buyer and seller. Other requirements of the webbing along with the methods of test are given in Table 2.

### 4.3 Treatment of Webbing

The webbing when required by the buyer shall be supplied impregnated with resin. Resin shall be polyvinyl butyral plasticized with butyl ricinoleate suitably applied from a water dispersion, dried and cured so as to form a firmly-adherent and evenly-distributed deposit or coating on the yarns of the webbing. The curing of the resin impregnated webbing shall be done in the temperature range of 115° to 186°C.

### 4.4 Resistance to Accelerated Ageing

The impregnated webbing shall have not less than 90 percent of the untreated breaking load, when tested according to the method given in Annex E.

### 4.5 Colour

When undyed webbing is impregnated, the colour may deviate from the natural state to that degree imposed by the colour of the treating agent used. However, in the case of dyed webbing being impregnated, the colour of the webbing shall match with the colour of the sealed sample (*see 4.10*).

**Table 1 Particulars of Nylon Webbing, Undyed or Dyed for Aeronautical Purposes**

( Clause 4.1 )

Type	Ends in Full Width, <i>Min</i>			Picks per dm	Weight <i>g/m, Max</i>	Width <i>mm</i>	Thickness <i>mm</i>	No. of Fold of Yarn			Weft	Breaking Strength on Full Width, 20 mm Strip, <i>kgf, Min</i>
	Face	+ Back	Binding					Face	Back	Binding		
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)	(12)	(13)
1	281		34	180 <sup>1)</sup>	90	44 + 1.5	2.0 to 3.0	2	2	1	1	2.950
2	Total 198			140 <sup>1)</sup>	60	44 + 1.5	1.1 to 2.0		2		1	1.815
Method of Test	IS 1963				Annex B	Annex C	IS 7702	–	–	–	–	IS 1969 (Part 1)

<sup>1)</sup> 2 picks/shed**Table 2 Other Requirements of Webbing**

( Clause 4.2 )

Sl No.	Characteristic	Requirement	Method of Test
(1)	(2)	(3)	(4)
1	pH of aqueous extract	5.5 to 8.0	IS 1390
2	Colour fastness to light	5 or better	IS/ISO 105-B01 : 2014 or IS/ISO 105-B02 : 2014
3	Colour fastness to washing	4 or better	IS/ISO 105-C10 : 2006 [Test Number A (1)]

**4.6 Weight**

An addition of 10 percent over the maximum weight specified in respect of untreated webbing shall be allowed for the impregnated webbing.

**4.7 Thickness**

The thickness of the impregnated webbing shall be not less than 12 percent of the maximum thickness specified for untreated webbing.

**4.8 Weight of Resin Deposition**

The treated webbing shall contain a maximum of 8.5 percent by weight of matter extractable in methyl ethyl ketone when tested by the method prescribed in Annex F.

**4.9 Resistance to Abrasion**

The impregnated webbing shall have not less than 85 percent of the untreated breaking load when tested by the method prescribed in Annex G.

**4.10 Sealed Sample**

If, in order to illustrate or specify the indeterminable characteristics like the type of finish, feel, etc, of the webbing, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

**4.10.1** The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

**5 MARKING**

**5.1** Each roll shall be legibly marked with the following information:

- Name of the material;
- Length of webbing contained in a roll;
- Year of manufacture;
- Colour fastness rating; and
- Manufacturer's name, initials or trade-mark, if any.

**5.2 BIS Certification Marking**

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the product(s) may be marked with the Standard Mark.

**6 PACKING**

A suitable number of rolls shall be arranged in the form of cylindrical bundles and secured by jute twine to form a pack. A suitable number of such packs shall be arranged and wrapped with polyethylene film (*see* IS 2508). The wrapped bundles shall be placed in a wooden packing case which is previously lined with one layer of waterproof packing paper (*see* IS 1398). The voids in the case, if any, shall be stuffed with cushioning material to avoid damage in transit.

The case shall be bound by iron hoops or wires. The gross weight of the case when packed shall not exceed 40 kg.

## 7 SAMPLING

**7.1** The quantity of nylon webbing of the same type and class delivered to a buyer against a despatch note shall constitute the lot.

**7.2** The conformity of the lot to the requirements of this standard shall be adjudged on the basis of the tests carried out on the samples selected from it.

**7.3** Unless otherwise agreed to between the buyer and the seller, the number of rolls to be selected from a lot shall be in accordance with col 2 and 3 of Table 3.

**7.4** The rolls selected according to 7.3 shall constitute the test sample for testing ends in full width, picks per decimetre, width, thickness and length.

**Table 3 Sampling Plan for Webbing**  
( Clauses 7.3, 7.5, 7.6 and 7.7 )

Sl No.	Lot Size	Sample Size	Permissible No. of Defectives	Sub-Sample Size
(1)	(2)	(3)	(4)	(5)
i)	Up to 50	8	0	3
ii)	51 to 150	13	0	4
iii)	151 to 300	20	1	5
iv)	301 to 500	32	2	7
v)	501 and above	50	2	10

**7.5** The number of rolls to be selected for testing breaking load, weight in grams per metre and pH value shall be according to col 5 of Table 3. These may be selected from those already tested in 7.4, For lot size less than 500, three rolls and otherwise 5 rolls shall be selected for testing colour fastness.

**7.6** In case the lot consists of treated webbing, the number of rolls to be selected for subjecting to the relevant tests shall be according to col 5 of Table 3.

### 7.7 Criteria for Conformity

The lot shall be declared conforming to the requirements of this standard if the following conditions are satisfied:

- The number of rolls found defective for any one or more of the characteristics (except length) tested in 7.4 does not exceed the corresponding number given in col 4 of Table 3.

NOTE — In the case of length, the value obtained for each roll shall be compared with its specified, declared or marked length. The mean percentage deficiency in length, if any, shall be determined and made applicable to the lot.

- From the test results for weight in grams per metre, the average ( $X$ ) and the range ( $R$ ) shall be calculated and the value of the expression  $X + 0.6 R$  does not exceed the corresponding limit.
- From the test results for breaking strength, the average ( $X$ ) and the range ( $R$ ) shall be determined and the value of the expression  $X - 0.6 R$  is greater than or equal to the corresponding limit specified.
- All the test results for pH value and colour fastness satisfy the relevant requirements.
- In case of treated webbings, all the test results satisfy the relevant requirements.

**ANNEX A**

( Clause 2 )

**LIST OF REFERRED INDIAN STANDARDS**

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
1390 : 2019/ ISO 3071 : 2005	Textiles — Determination of pH of aqueous extract ( <i>second revision</i> )	7702 : 2012/ ISO 5084 : 1996	Textiles — Determination of thickness of textiles and textile products ( <i>first revision</i> )
1398 : 1982	Specification for packing paper water proof, bitumen-laminated ( <i>second revision</i> )	IS/ISO 105-B01 : 2014 to	Textiles — Tests for colour fastness: Part B01 Colour fastness light: Daylight (superseding IS 686 : 1985)
1963 : 1981	Methods for determination of threads per unit length in woven fabrics ( <i>second revision</i> )	IS/ISO 105-B02 : 2014 to	Textiles — Tests for colour fastness: Part B02 Colour fastness artificial light: Xenon arc fading lamp test (superseding IS 2454 : 1985)
1969 (Part 1) : 2018/ ISO 13934-1:2013	Textiles—Tensile properties of fabrics : Part 1 Determination of maximum force and elongation at maximum force using the strip method ( <i>fourth revision</i> )	IS/ISO 105-C10 : 2006 to	Textiles — Tests for colour fastness: Part C10 Colour fastness washing with soap or soda (Superseding IS 687 : 1979, IS 764 : 1979, IS 765 : 1979, IS 3361 : 1979 and IS 3417 : 1979)
2508 : 2016	Polyethylene films and sheets — Specification ( <i>third revision</i> )		

**ANNEX B**

( Table 1 )

**METHOD FOR DETERMINATION OF WEIGHT PER METRE****B-1 TEST SPECIMENS**

Cut a piece of webbing approximately 4 m in length from each of the rolls constituting the sample under test (*see 7.4*).

**B-2 CONDITIONING OF TEST SPECIMENS**

Prior to test, the test specimen shall be conditioned in a standard atmosphere at  $65 \pm 2$  percent RH and  $27^\circ \pm 2^\circ\text{C}$  temperature for 24 h.

**B-3 PROCEDURE**

**B-3.1** Take a test specimen and apply a tension equal to 1 percent of the minimum breaking load of the webbing. After  $60 \pm 5$  seconds, mark in the length in tension two separate 1 m specimens at the marks and determine the weight of each specimen to the nearest gram.

**B-3.2** Repeat the test with the remaining test specimens.

**ANNEX C**

( Table 1 )

**METHOD FOR DETERMINATION OF WIDTH OF THE WEBBING****C-1 TEST SPECIMENS**

For the purpose of this test, all the rolls in the test sample (*see 7.4*) shall constitute the test specimens.

**C-2 PROCEDURE**

**C-2.1** Unroll one test specimen and lay a portion of it on a horizontal surface and smooth it out with no greater tension than is necessary to make it lie straight and flat.

**C-2.2** Measure to an accuracy of 1 mm, the width of the webbing by means of a graduated steel scale placed at right angles to the selvages.

**C-2.3** Determine similarly the width of the webbing at 5 different places uniformly distributed along the length of the roll. Calculate the mean of the 5 test values.

**C-2.4** Repeat the test with the remaining test specimens.

**ANNEX D**

( Clause 4.2 )

**METHOD FOR DETERMINATION OF LENGTH OF ROLL****D-1 TEST SPECIMENS**

For the purpose of this test, all the rolls in the test sample (*see 7.4*) shall constitute the test specimens.

**D-2 EQUIPMENT**

A flat table little over 5 m long having a smooth horizontal surface with markings in metres and centimetres on one side shall be used.

**D-3 PROCEDURE**

**D-3.1** Unroll one test specimen and draw one of its ends across the full length of the table and smoothen the portion of the webbing on the table with no greater

tension than is necessary to make it lie straight and flat.

**D-3.2** Mark on the webbing the first 5 m length as measured against the mark on the table. Measure the entire length in 5 m lengths till a length less than 5 m remains. Measure this length correct to a centimetre in metres and centimetres against the markings on the table.

**D-3.3** Compare the value obtained as in **D-3.2** with the declared or marked length of the roll and note the deficiency in length, if any.

**D-3.4** Repeat the test with the remaining test specimens and calculate the mean percentage deficiency in length, if any.

**ANNEX E**

( Clause 4.4 )

**METHOD FOR ACCELERATED AGEING OF IMPREGNATED WEBBING****E-1 TEST SPECIMEN**

For the purpose of this test, all the impregnated webbing rolls in the sample shall constitute the test specimen (*see 7.6*).

**E-2 EQUIPMENT**

An accelerated weathering unit consisting essentially of the following features:

- a) Vertical carbon arc mounted at the centre of a vertical cylinder. The arc shall be designed to accommodate either 2 or 3 pairs of carbon but shall burn only 1 pair at a time automatically transferring from one pair to another as the carbons arc consumed. The arc shall be operated on 60 A and 50 V across the arc for a.c. and on 50 A and 60 V across the arc for d.c.

- b) The arc shall be surrounded by removable panels (or filters) having good absorbing or transmitting properties.
- c) A rotating rack with holders in which the specimens shall be placed side by side and exposed to radiation from the arc with the centre of the face of the specimen at a radial distance of approximately 45 cm from the arc. The rack shall rotate about the arc at a uniform speed of about 1 to 2 rev/min.
- d) Water spray nozzles mounted horizontally in the test chamber inside the specimen rack and so placed that water shall strike the specimens evenly over the entire length in the form of a fine spray in sufficient volume to cover the specimens immediately on impact. The apparatus shall be operated so that the specimens are exposed to successive cycles of 102 min of light without spray followed by 18 min of light with spray.
- e) Means for maintaining the required temperature of water in the spray, namely,  $26.7 \pm 5.6$  °C.
- f) Means for maintaining the required pressure of water entering the spray, namely, 0.844 to 1.265 kg/cm<sup>2</sup>.
- g) Means for delivering the required quantity of water per spray nozzle to the specimen, namely, 0.5 to 1 l/h per spray nozzle.
- h) Means for maintaining the air temperature within the machine, namely, at  $68 \pm 5.7$  °C with the filters in place at the exposure plane of the specimen rack, and at  $80 \pm 5.7$  °C when filters are removed; means for measuring the temperature.

### E-3 PROCEDURE

Take 5 test specimens of impregnated webbing and 5 specimens of untreated webbing. Place them side by side in the rack arranging in such a way that one impregnated webbing alternates with that of one untreated webbing. The specimens shall be placed 2.5 cm apart. Expose the specimens to carbon arc light source for a total of 100 h. Remove the test specimen at the end of the exposure period and condition them to standard atmospheric conditions for 24 h. When the test specimens have been conditioned, test them for breaking load by the method given in Table 1.

## ANNEX F

( Clause 4.8 )

### METHOD FOR DETERMINATION OF WEIGHT OF RESIN DEPOSITION

#### F-1 TEST SPECIMEN

For the purpose of this test, all the impregnated webbing rolls in the test sample shall constitute the test specimen (see 7.6).

#### F.2 APPARATUS

##### F-2 1 Soxhlet Apparatus

##### F-2.2 Methyl Ethyl Ketone

#### F-3 PROCEDURE

**F-3.1** Take a test specimen of impregnated webbing and remove from it warp and weft yarn so that the yarns weigh about 5 g. Dry the sample to constant weight in

a weighing bottle at a temperature of  $104 \pm 4.5$  °C. Extract the test specimen with methyl ethyl ketone in a soxhlet apparatus for 6 h. Determine the final weight of the extracted specimen after constant weight has been obtained under the same drying conditions as mentioned above.

**F-3.2** Calculate the percentage weight of resin deposit by the following formula:

Percentage weight of resin deposit =

$$\frac{\text{Loss in weight on extraction}}{\text{Dry weight of sample}} \times 100$$

**F-3.3** Repeat the test with the remaining test specimens.



## ANNEX G

( Clause 4.9 )

## METHOD FOR DETERMINATION OF RESISTANCE TO ABRASION

## G-1 TEST SPECIMENS

For the purpose of this test, all the impregnated webbing rolls in the test sample shall constitute the test specimen (see 7.6).

## G-2 EQUIPMENT

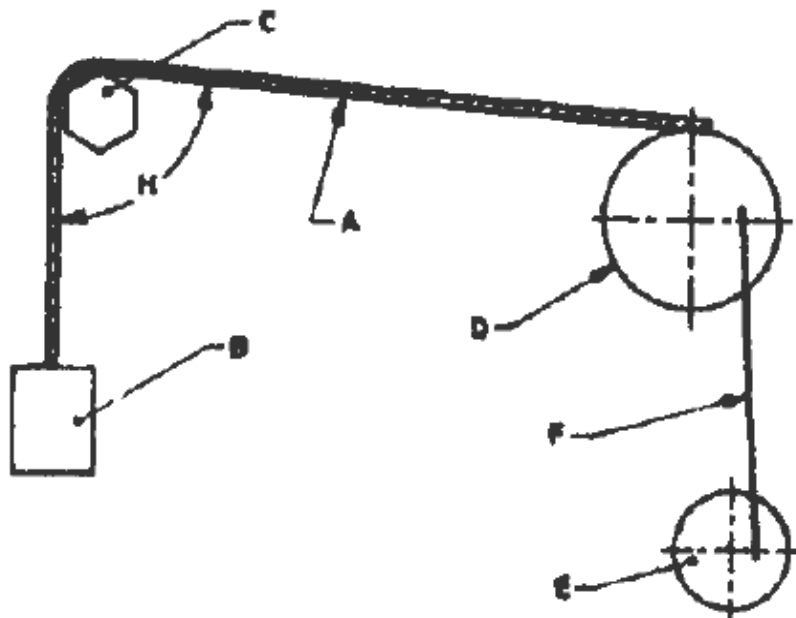
A device as illustrated schematically in Fig. 1.

## G-3 PROCEDURE

Take one test specimen of impregnated webbing *A* and attach weight *B* to one end. Pass the webbing

over the hexagonal bar *C* and attach the other end of the webbing to the oscillating drum *D*. Oscillate the drum so that the webbing is given a  $30 \pm 2.5$  cm traverse over the hexagonal bar at the rate of  $60 \pm 2$  strokes/min. In this way, impart 5 000 strokes to the webbing. Remove the webbing on expiry of the last stroke and determine its breaking load by the method specified in Table 1.

G-4 Repeat the test with the remaining test specimens but changing the edges of the hexagonal bar for each test specimen tested.



- A — Webbing
- B — Weight,  $2.4 \pm 0.06$  kg
- C — Hexagonal rod, 6.35 A/F, cold rolled, 97 to 101 RHB
- D — Drum 400 mm dia
- E — Crank
- F — Connecting rod
- H — Angle formed by webbing  $85 \pm 2^\circ$

FIG. 1 SCHEMATIC DIAGRAM OF ABRASION RESISTANCE TESTING DEVICE

## ANNEX H

( Foreword )

## COMMITTEE COMPOSITION

Textile Materials for Aeronautical and Related Products Sectional Committee, TXD 13

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Amendments are issued to standards as the need arises on the basis of comments. Standards are also reviewed periodically; a standard along with amendments is reaffirmed when such review indicates that no changes are needed; if the review indicates that changes are needed, it is taken up for revision. Users of Indian Standards should ascertain that they are in possession of the latest amendments or edition by referring to the latest issue of 'BIS Catalogue' and 'Standards: Monthly Additions'.

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